

Friday, June 26, 2009 9:03:22 AM



Accept

**Setup Start**

Stop



Item Name: Bracket

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3610	Rev A								
100	BAND SAW	0.00				30	✓		
	Memo	0.00							
Bandsaw	Cut blank 6.600 " long								
Jeaspa Bandsaw	M112397								
			G.A	09/08/15					
110	HAAS CNC VERTICAL MACHINING #1	0.00				30	✓		
	Memo	0.00							
HAAS 1	1- Mill as per Folio FA692 Rev: A & Dwg D3610 Rev: A □2-Deburr								
HAAS CNC vertical machine #1	per dwg D3610								
			G.A	09/08/15					
120	QC2- Inspect parts off machine FAI/FAIB	0.00				30	✓		
	Memo	0.00							
QC									
Quality Control									
			G.A	09/08/15					

Picklist Print

Friday, June 26, 2009 9:03:22 AM

Page 1

Work Order ID: 47144



Parent Item: D3610-041RevA



Parent Item Name: Bracket



Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-4 		Purchased	No			110	Each	0.0000	20.0000		<i>Ep 09/09/10</i>	
RIVET MS21075L3 		Purchased	No			180	Each	0.0000	10.0000		<i>Ep 09/09/10</i>	
Nutplate												

M104374

M112640

Date: Tuesday, 14/04/2009 11:04:28 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 47144	
Estimate Number : 12812	
P.O. Number :	Part Number : D3610041
This Issue : 14/04/2009 S.O. No. :	Drawing Number : D3610 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 46283	Material :
Written By :	Due Date : 21/04/2009 Qty: 30 Um: Each
Checked & Approved By : <u>mf 09-04-14</u>	
Comment : est rev A new issue 07.03.28 EC est rev B released, changed mat'l EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0 ✓	M4140NB1500X1500	4140 Steel Bar 1.50 x 1.50
-------	------------------	----------------------------



(30)

Comment: Qty.: 0.5775 f(s)/Unit Total : 5.7750 f(s)

AISI 4140 Steel Bar

M112397

H.A 09/08/15

2.0 ✓	BAND SAW	BAND SAW
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(30)

Comment: BAND SAW

Cut blank 6.600 " long

H.A 09/08/15

3.0 ✓	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(30)

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: A & Dwg D3610 Rev: A

2-Deburr per dwg D3610

H.A 09/08/15

4.0 ✓	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-------	-----	--



(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/08/15

5.0 ✓	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: - Tuesday, 14/04/2009 11:04:28 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47144

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

7.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 070817

count
830

8.0



POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

9.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0



MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nutplate
Batch: _____

11.0



MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
RIVET
batch: _____

12.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet Nut Plate as per Dwg D3610

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/04/2009 11:04:28 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47144

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorter (x32)

14.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial, all entries

DART AEROSPACE LTD		Work Order:	47141
Description: Plate		Part Number:	D3610-1
Inspection Dwg: D3610 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.248	✓			
0.250	+/-0.010	0.256	✓			
0.63	+/-0.030	0.625	✓			
6.50	+/-0.030	6.507	✓			
3.00	+/-0.030	3.000	✓			
2.677	+/-0.010	2.677	✓			
0.38	+/-0.030	0.377	✓			
Ø0.277	+0.006/-0.001	Ø0.279	✓			
Ø0.201	+0.005/-0.001	Ø0.204	✓			
Ø0.098	+0.004/-0.001	Ø0.099	✓			
0.88	+/-0.030	0.875	✓			
0.94 x 0.50	+/-0.030	0.938 x 0.501	✓			
0.250	+/-0.010	0.253	✓			
0.125 depth	+/-0.010	0.127 depth	✓			

Measured by:	G. A	Audited by:	SA	Prototype Approval:	N/A
Date:	09/08/15	Date:	09/08/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue P/O D3610-041	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

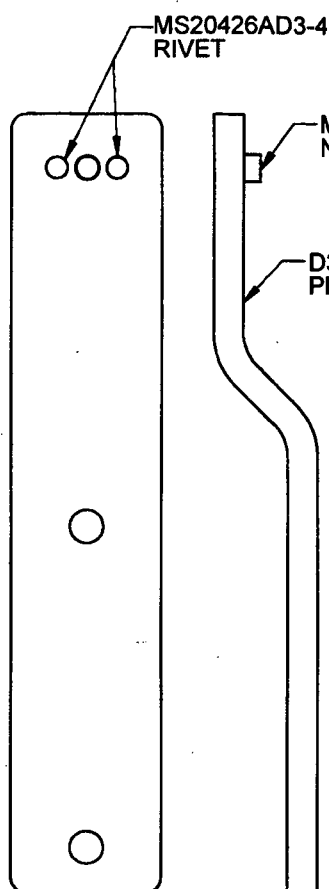
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

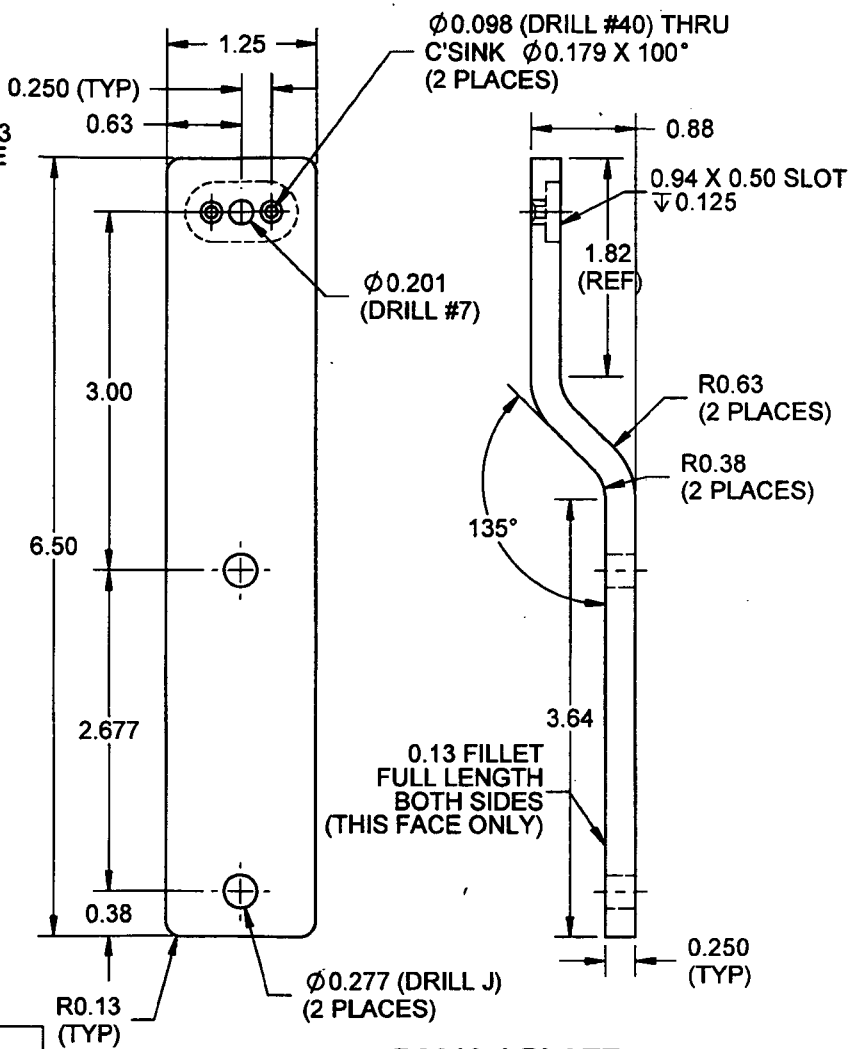
NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



D3610-041 BRACKET



D3610-1 PLATE

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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#47144
RELEASED
07.04.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries